

Work Order ID 110015

December-17-13 9:06:11 AM

D 3859-041

\*110015\*

Page 1

Item ID: D3859-041

B 110015

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Wearplate

Start Date: 12/12/13 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Run Start

\*NR1\*

Approvals: Process Plan:      Date: 13-12-17 Tooling:      Date:     

Stop

\*NR2\*

QC:      Date:      SPC (Y/N):      Date:     

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3859

REV A

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3859 Dwg Rev: A Prog Rev: A 2-  
Deburr if necessary

304-063

8 0 Jm14-02-11

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

8 0 Jm14-02-11

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control

DAS

27

3-89

14/2/13

8

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Item ID: D3859-041	Accept	<b>*N9000040100*</b>	Setup	Start	<b>*NS1*</b>
Revision ID:				Stop	<b>*NS2*</b>
Item Name: Wearplate					
Start Date: 12/12/13	Start Qty: 6.00	<b>*6*</b>	Cust Item ID:		
Required Date: 12/17/13	Req'd Qty: 6.00	<b>*6*</b>	Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	<b>*NR1*</b>
	QC:	Date:	SPC (Y/N):	Date:		Stop	<b>*NR2*</b>

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Large Fab	0.00							
<b>*130*</b>									
Large Fab	Memo	0.00							
Large Fab	1-Weld D3009-3 cups as per dwg D3859 A/R 316L stainless steel rod Batch: <u>M125054</u> 2-Weld hard facing as per Dwg D3859 A/R 2059B Hard Coat rod Batch: <u>M126049</u> *****use DT9462 for welding***** <u>L-20596</u>								
140	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									
150	QC5- Inspect part completeness to step on W/O	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									

⑧ me 14.03.13

⑧ 14-03-13 DAS  
9  
9-89

⑧ 1403-13 DAS  
9  
9-89

0-193

# Work Order ID 110015

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Item ID: D3859-041 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Wearplate  
 Start Date: 12/12/13 Start Qty: 6.00 \*6\* Cust Item ID:  
 Required Date: 12/17/13 Req'd Qty: 6.00 \*6\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 <b>*160*</b> Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per OSI005 4.3 <i>M125028</i> Memo START TIME: <i>8:00</i> OVEN TEMPERATURE: <i>7:15</i> FINISH TIME: <i>3:00</i>	0.00 0.00				<i>8</i>	<i>8</i>		<i>man 6/50</i> <i>14/03/15</i>
170 <b>*170*</b> QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>8x</i>		<i>14-3-18</i>	DAS 26 9-89
180 <b>*180*</b> Packaging Packaging	Identify as per dwg & Stock Location <i>8T257</i> Memo	0.00 0.00				<i>8x</i>		<i>14-3-18</i>	DAS 26 9-89

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Item ID: D3859-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Wearplate

Start Date: 12/12/13 Start Qty: 6.00 **\*6\***

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 6.00 **\*6\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

14-03-19

ME  
14-3-18



# Picklist Print


December-17-13 9:06:10 AM

Page 1

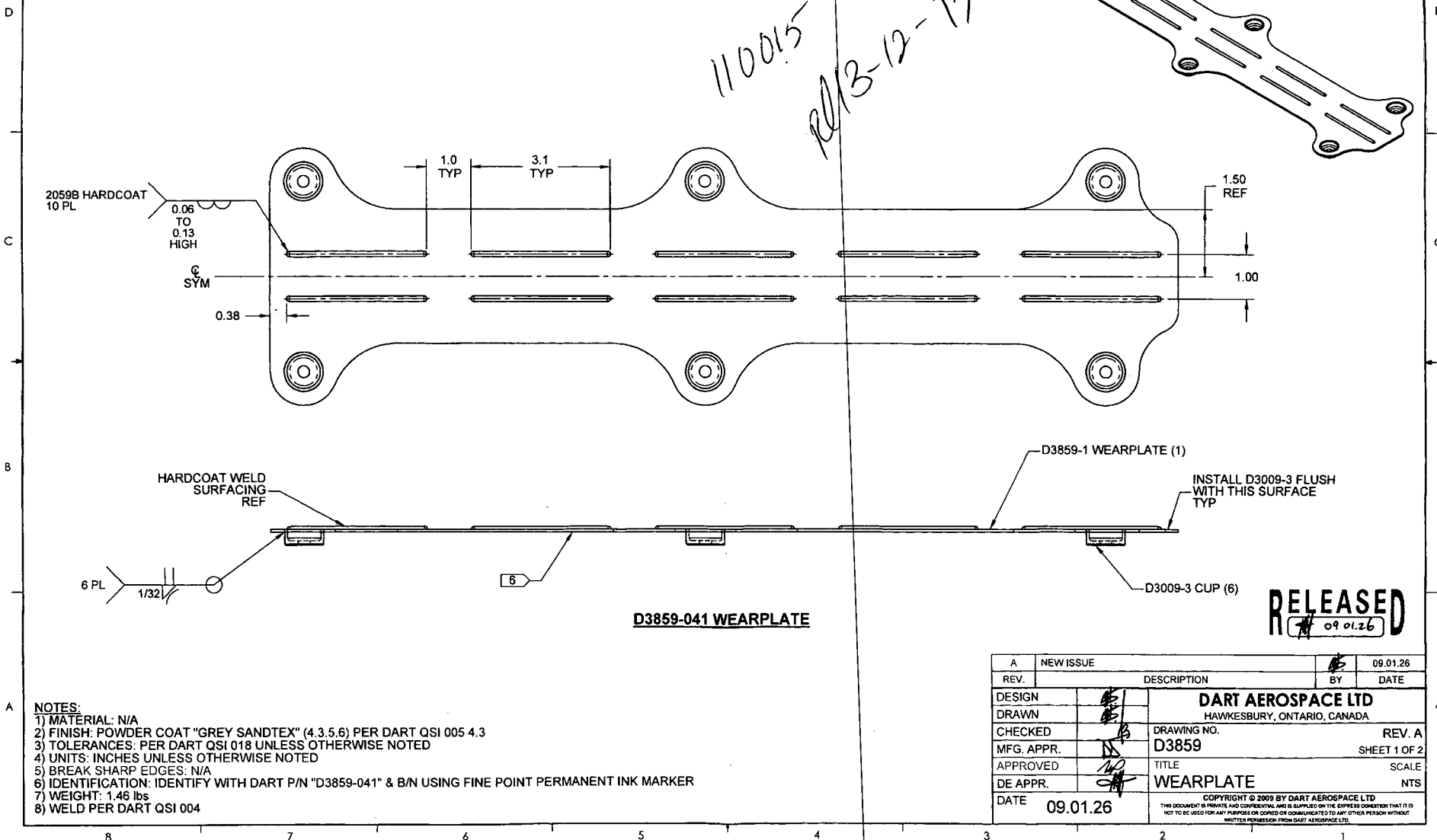
Work Order ID: 110015  
Parent Item: D3859-041  
Parent Item Name: Wearplate

Start Date: 12/12/13 Required Date: 12/17/13  
Start Qty: 6.00 Required Qty: 6.00

Comments: IPP Rev:A 09-02-03 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	210.6540	0.85	<del>5</del> 7		Jm14-02-11	
				<u>Location</u>		<u>Loc Qty</u>				<u>Loc Code</u>			
				MAT020		210.6539998							
				123136		140.2							
				M126159		25.94							
				M126915		44.514				123054			
 D3009-3 Cup		Manufactured	No		128054	130	Each	196.0000	6	<del>26</del> 48		me 14.03.10	
				<u>Location</u>		<u>Loc Qty</u>				<u>Loc Code</u>			
				WA001		196							
				103891		34							
				107642		8							
				108451		60							
				109092		60				x48			
				79078		30							
				88386		3							
				93296		1							

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3859-041	WEARPLATE
2	1	D3859-1	WEARPLATE
3	6	D3009-3	CUP

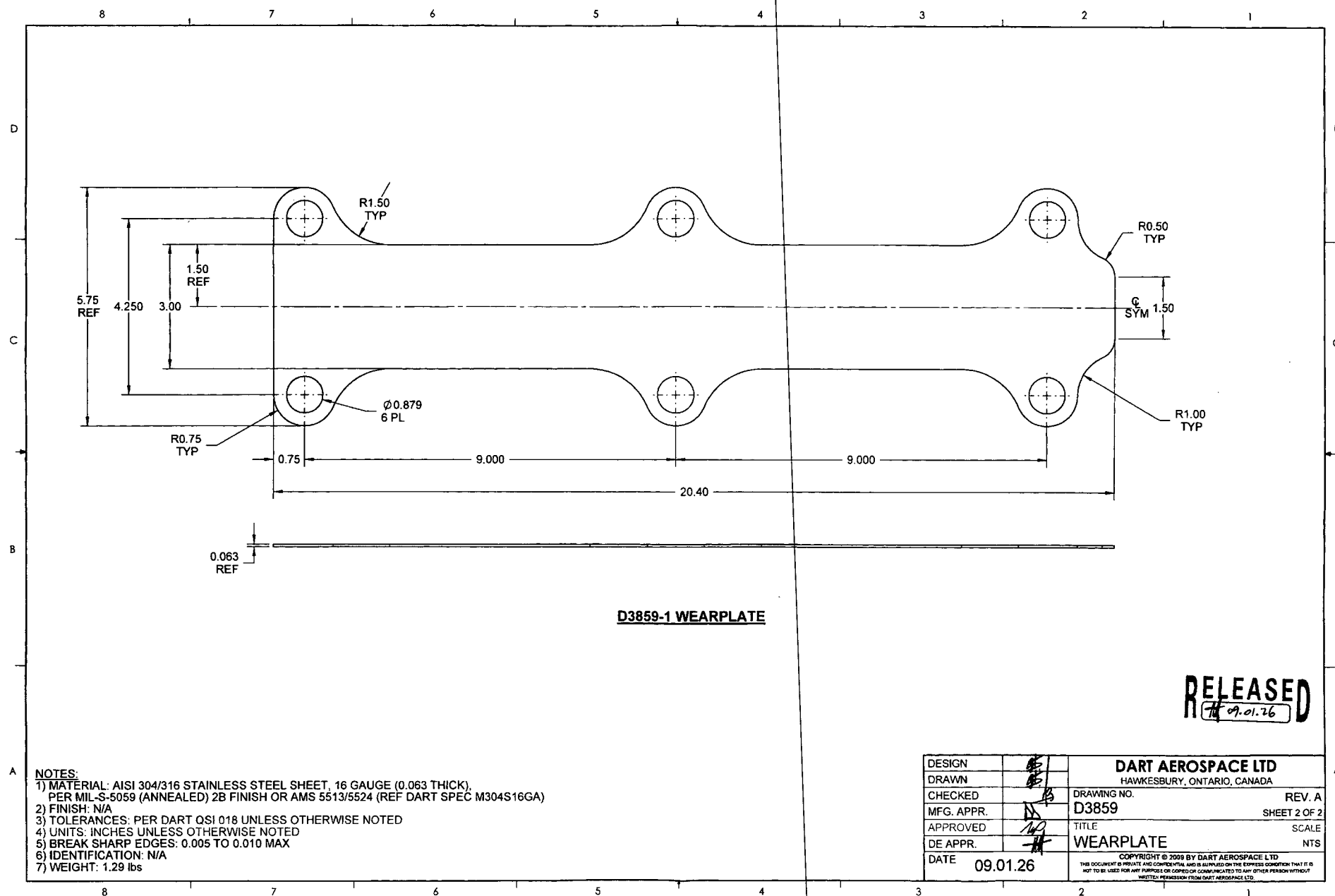


REV.	NEW ISSUE	DESCRIPTION	BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	09.01.26			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A SHEET 1 OF 2
DRAWING NO. D3859	SCALE NTS
TITLE WEARPLATE	

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**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK), PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524 (REF DART SPEC M304S16GA)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.29 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D3859</b>	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		<b>WEARPLATE</b>	NTS
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